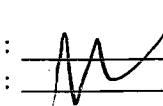


Date: Tuesday, 29/04/2008 11:22:18 AM
 User: Melanie Fauteux

Process Sheet

OK

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: FRONT RAIL, LH
Job Number	: 38868		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D37661
This Issue	: 29/04/2008 S.O. No. :	Drawing Number	: PROTOTYPE
Prsht Rev.	: NC	Project Number	:
First Issue	: 29/04/2008 Type : R & D SM/MED FAB	Drawing Revision	: 08.04.30
Previous Run	: 38866	Material	:
Written By	: 	Due Date	: 16/05/2008 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

MAKE PER DRWG D3766 REV A

FF 08-05-15

2.0	M304TR1000W155	304 RD Tube 1.0" x .155W
-----	----------------	--------------------------



304 RD TUBE 1.0" x .188W



Comment: Qty.: 2.9300 (s)/Unit Total: 2.9300 (s)

UP 08.04.30

FF 08-05-15

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



ENGINEERING APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

PH 08.05.21

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

GIVE TO CHRIS P-ENG

FOR ENGINEERING USE ONLY

CHARGE TO JOB #00196

PH 08.05.29

5.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



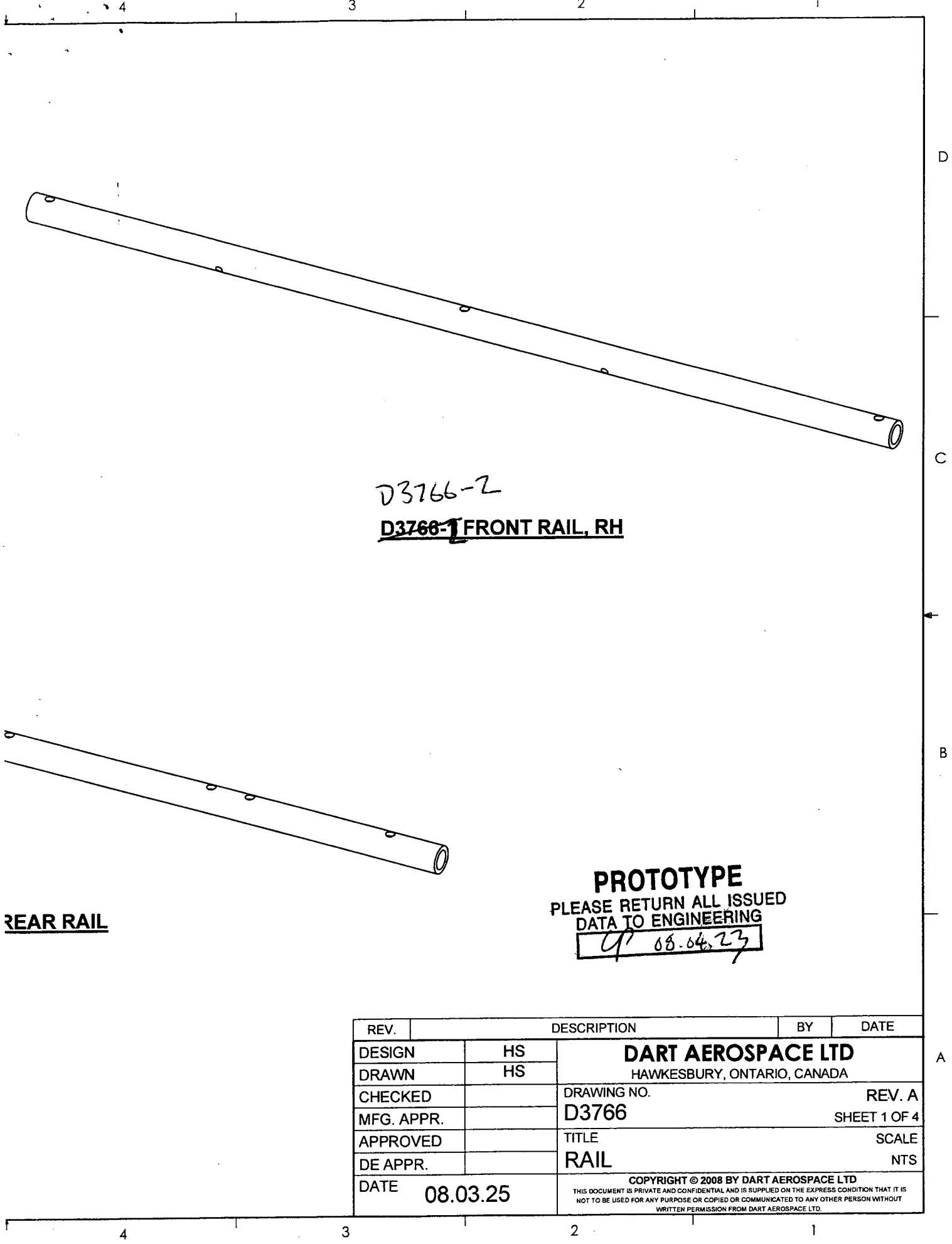
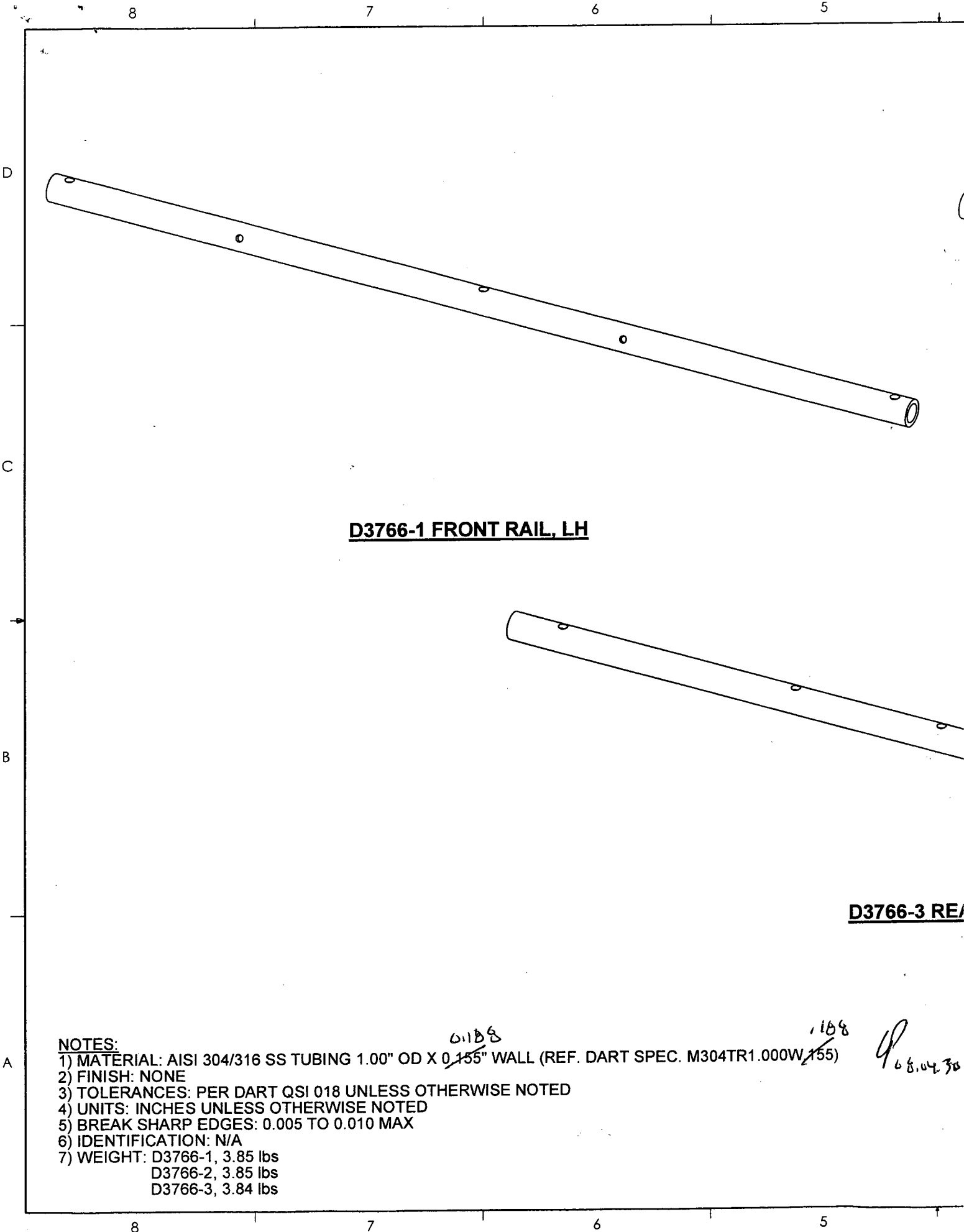
Comment: FINAL INSPECTION/W/O RELEASE

PH 08.05.29 Prototype

Job Completion



PH 08/06/11



REV.	DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	HS			
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3766	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		RAIL	NTS	
DATE	08.03.25		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

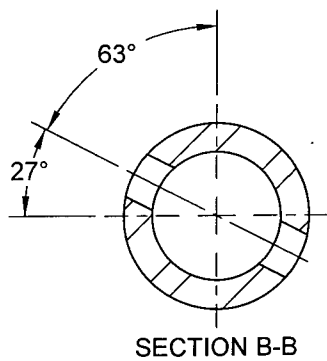
Q 68.64.30

0.188
0.155
(REF)

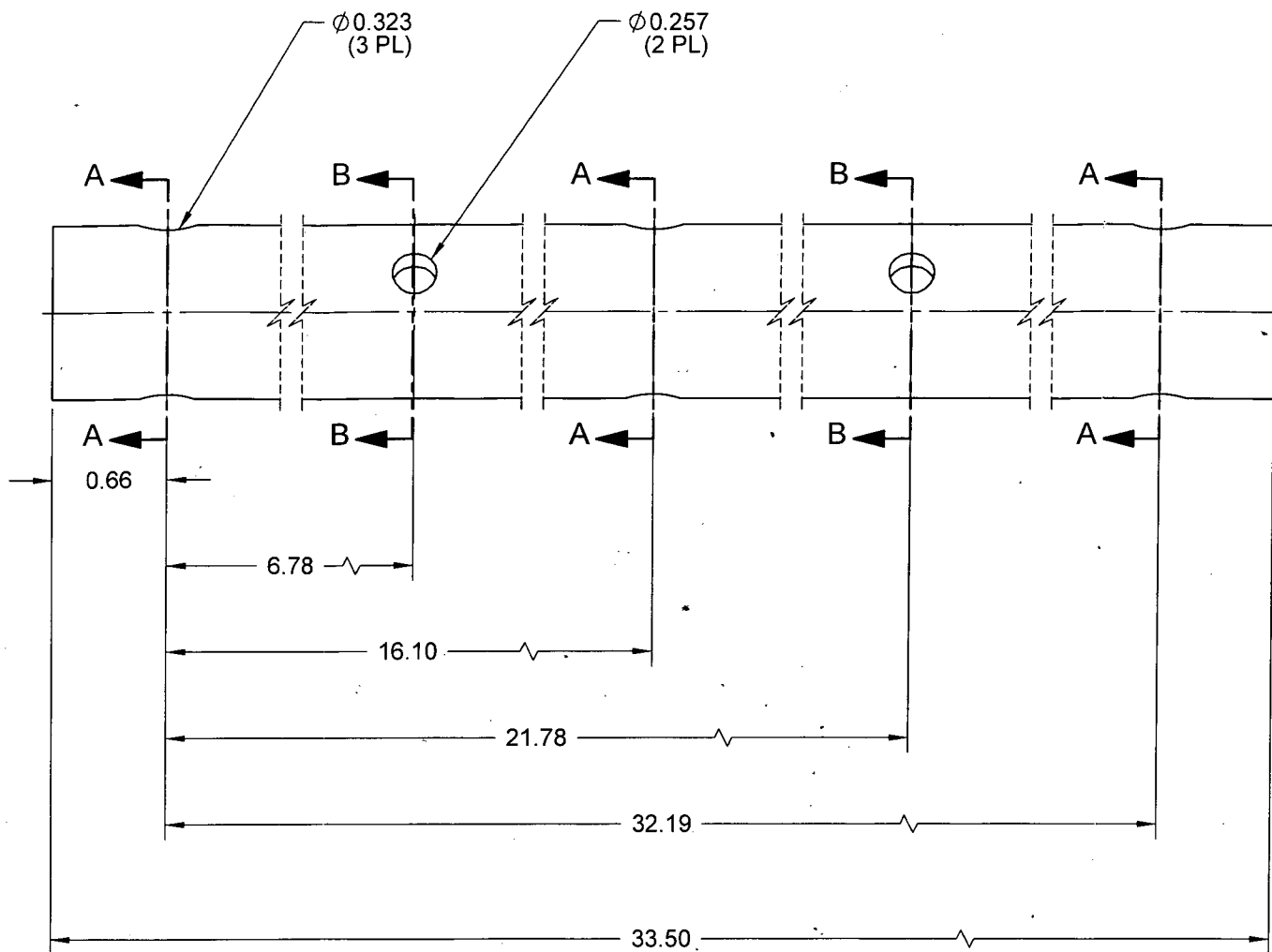
Ø1.000
(REF)

90°

SECTION A-A



SECTION B-B



D3766-1 FRONT RAIL, LH

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
UP 08.04.23

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3766	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RAIL	1:1
DATE	08.03.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Receiving Report

Date: 8/07
Supplier: MAGNA

Batch No: M107952
Dart P/O: 6270

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐
Waybill Attached: Yes ☐ No ☒
Shipment Complete: Yes ☒ No ☐ N/A ☐
QC6 Inspection 2008/07 N/A ☐
Work Order N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin:
Date: 08/05/08
Received/Costing: RCP 7826
Initial: CL

Location

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

Heat # 168/12-3

RECEIVED MAY 13 2008

Sub-Total
G.S.T.

1090.00
54.50

TOTAL →

1144.50

FRAIS D'ADMINISTRATION DE 1½% PAR MOIS (18% PAR ANNÉE) SUR COMPTE PASSÉ DÙ.
LE PRÉSENT CONTRAT SERA RÉGI PAR LES LOIS DE LA PROVINCE DE QUÉBEC ET COMME
AYANT PRIS NAISSANCE DANS LE DISTRICT JUDICIAIRE DE MONTRÉAL.
ADMINISTRATION CHARGES OF 1½% PER MONTH (18% PER YEAR) ON OVERDUE ACCOUNTS.
THE PRESENT AGREEMENT SHOULD BE GOVERNED BY THE QUEBEC LEGISLATION AND SHOULD
BE CONSIDERED AS HAVING ORIGINATED IN THE JUDICIAL DISTRICT OF MONTREAL.



Shanghai Huaerde Stainless Steel Pipe Manufacture Co., Ltd.

Chihua Road, Shanghai Chemical Industry Park(Section B)
Fengxian District, Shanghai.201417 China

A PED& AD-W2 Certified Company

Mill Test Report

HED39569-04

According to EN10204 - 3.1



Certificate No. 01 200 07-10-10-1241

Customer Name		Material Specification	ASTM A/SA-213 A269 NACE MR0175 TP316/316L OD 220 GRIT POLISHING
Purchase Order No.	39569	Heat Treatment	Solution Annealed in the temperature of 1040°C for 20 minutes and Quenched by water
Description	Cold Finished Seamless Austenitic Stainless Steel Tubes	Heat No.	8-109

ELEMENTS	C %	Mn %	P %	S %	Si %	Cr %	Ni %	Mo %		Lot No.	Yield Strength	Tensile Strength	Elongation	Hardness HRB
SPECIFICATION	Max 0.035	Max 2.00	Max 0.045	Max 0.030	Max 1.00	16.0 ~18.0	10.0 ~14.0	2.0 ~3.0		8-109	Min.205MPa	Min.515 MPa	Min.35%	Max.90
RESULTS(LADLE)	0.018	1.34	0.005	0.024	0.40	16.40	10.14	2.13		07-10-15-88-1	245	539	46%	77
RESULTS(PRODUCT)	0.020	1.25	0.005	0.013	0.51	16.47	10.13	2.17		07-10-15-88-2	247	543	48%	81

C) Extend of material delivery

Item No.	Quantity	Descriptions	Heat No.	Lot No.
1	1120 ft	1" x .049" x 20'	8-109	07-10-15-88
2	1880 ft	1" x .065" x 20'	8-109	07-10-15-88
3	520 ft	1" x .188" x 20'	8-109	07-10-15-88
4	500 ft	35mm x 2.5mm x 20'	8-109	07-10-15-88

D) Hydrostatic Test, NDT and Dimensional check, etc.

Testing Item	Details	Results
Dimensional / Visual	ASTM A999	Satisfactory
Hydrostatic Pressure test	ASTM A999	Satisfactory
Flattening Test	ASTM A1016	Satisfactory
Flaring Test	ASTM A1016	Satisfactory
Inter-granular Corrosion test	ASTM A262 E	Satisfactory

E) Steel Making Process

Electrical Furnace

F) Statement

1. No weld repair performed for billet and pipe
2. The Materials have been manufactured, tested and examined in acc. with all the requirements of the ordered standards and we confirm that all test results are acceptable.

Date	November 24, 2007	Mill inspector	Li Bin	Approved by QC manager	
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